

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : SEAT BELT GUIDE ASSEMBLY

Job Number : 47231 - 2

Estimate Number : 13860

P.O. Number :

Part Number : D39205

This Issue : 15/04/2009 S.O. No. :

Drawing Number : D3920 PREL

Print Rev. : NC

Project Number : N/A

First Issue : 11 Type : MACHINED PARTS

Drawing Revision : PREL

Previous Run : 47224

Material :
Due Date : 22/04/2009

Qty: 4 Um: Each

Written By : YMF 09-04-15

Checked & Approved By :
Comment : Est Rev:A New Issue 09-04-15 JLM Verified By:EC

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0750X01000

6061-T6 Bar .750 x 1.00



Comment: Qty.: 0.7875 f(s)/Unit Total : 3.1500 f(s)

6061-T6 Bar .750 x 1.00

BATCH: M104186

M.A 09/04/22 (4)

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank 23.800" long

M.A 09/04/22 (4)

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA810 Rev: AA & Dwg D3920 Rev: PREL

09/04/24 (4)

2-Deburr per dwg D3920

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/04/24 (4)

5.0

QC8

SECOND CHECK

ENGINEERING
APPROVAL



Comment: SECOND CHECK

09-04-24 AJS 09-04-24 (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT GUIDE ASSEMBLY

Job Number: 47231

Part Number: D39205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMPI/BK

(14)
09/04/24

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109091

START TIME:

10:15

OVEN TEMPERATURE:

320°

FINISH TIME:

10:45

BL 09-04-24.

(14)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/04/24 (14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 261. emf 09-04-24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)
09/04/24

Job Completion



UMF 09-04-24

POSITIVE RECALL

EFFECTIVE

09/04/24

AUTH

11

RELEASED

155

DATE


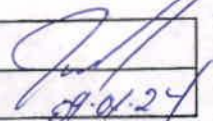
09.04.24

DART AEROSPACE LTD		Work Order: 47231
Description: Seat Belt Guide Assembly		Part Number: 3920-5
Inspection Dwg:	Rev: PREL	Page 1 of 1

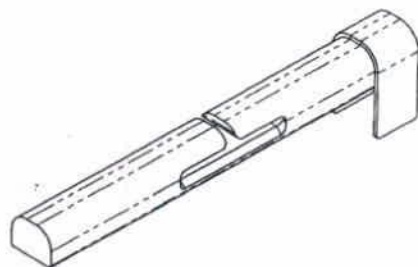
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

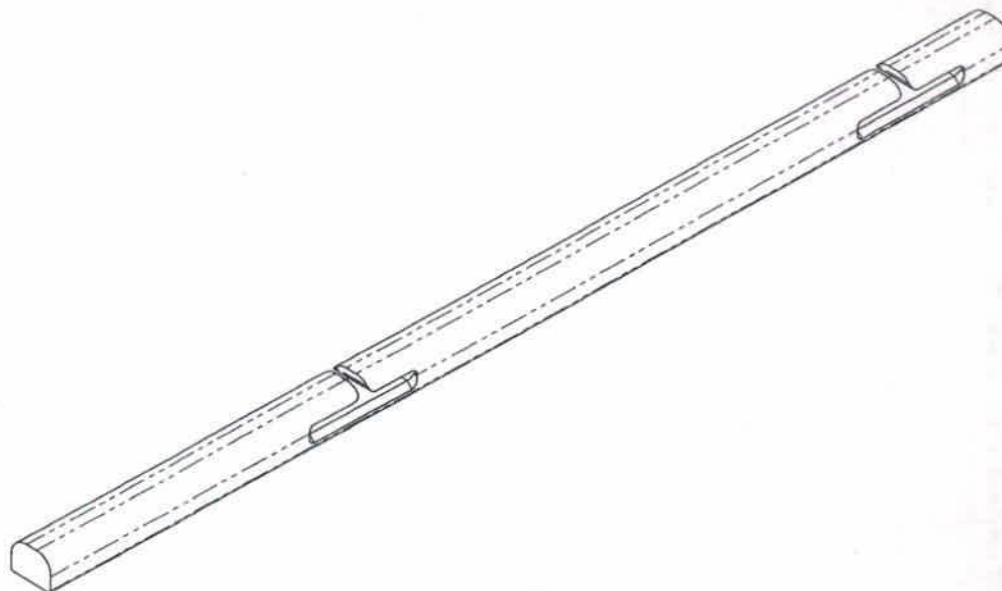
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.63	$\pm .030$	2.62	✓			
14.56	$\pm .030$		✓			
1.19	$\pm .030$	1.189	✓			
23.63	$\pm .030$	23.63	✓			
13.38	$\pm .030$	13.38	✓			
.25	$\pm .030$.26	✓			
2.38	$\pm .030$	2.37	✓			
R.13	$\pm .030$.13	✓			
R.38	$\pm .030$.375	✓			
R.06	$\pm .030$.0625	✓			
.25	$\pm .030$.26	✓			
.25	$\pm .030$.238	✓			
1.00	$\pm .030$.999	✓			
113x45°	$\pm .030 \times .50$	113x45	✓			

Measured by: 	Audited by: 	Prototype Approval:
Date: 09/04/24	Date: 09-01-24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3920-041 SEATBELT GUIDE ASSEMBLY



D3920-5 SEATBELT GUIDE

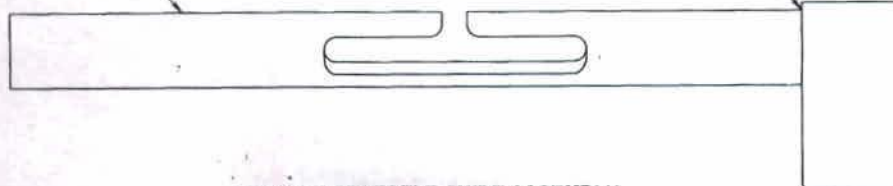
**PRELIMINARY
ISSUE**

AJS 09.04.14

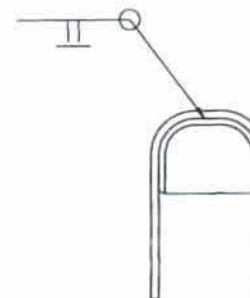
A	NEW ISSUE	AJS	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3920	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.03.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD</small> <small>THIS DOCUMENT IS PRELIMINARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMERCIAL OR INDUSTRIAL PURPOSE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3920-041	SEATBELT GUIDE ASSEMBLY
9	1	D3920-1	SEAT BELT GUIDE
10	1	D3920-3	BRACKET

D3920-1
SEAT BELT GUIDE



D3920-041 SEATBELT GUIDE ASSEMBLY



**D3920-3
SEATBELT GUIDE BRACKET
(ASSEMBLE AT
CHAMFERED END)**

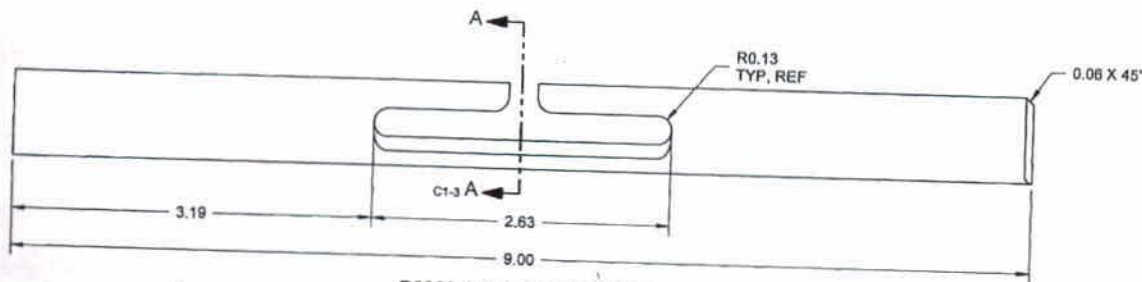
**PRELIMINARY
ISSUE**

ASS 09.04.14

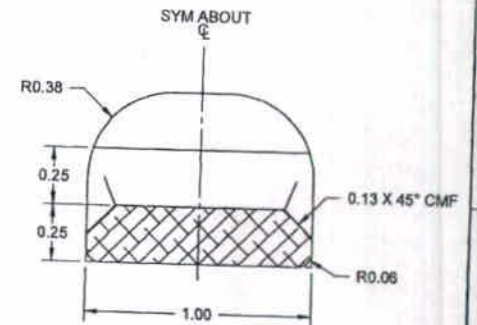
NOTES: D3920-041

- 1) MATERIAL:
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

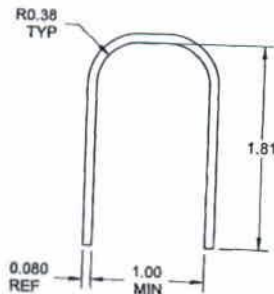
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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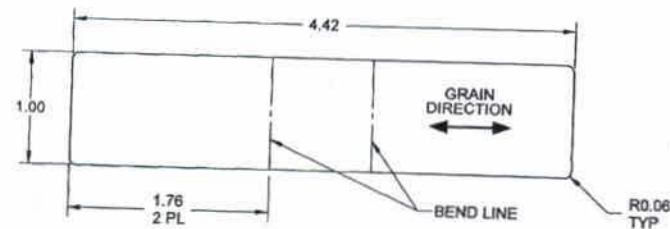
D3920-1 SEATBELT GUIDE



SECTION A-A
SCALE 2X



D3920-3 SEATBELT GUIDE BRACKET
(MAKE FROM D3920-3F)



D3920-3F FLAT PATTERN

NOTES: D3920-1A-3

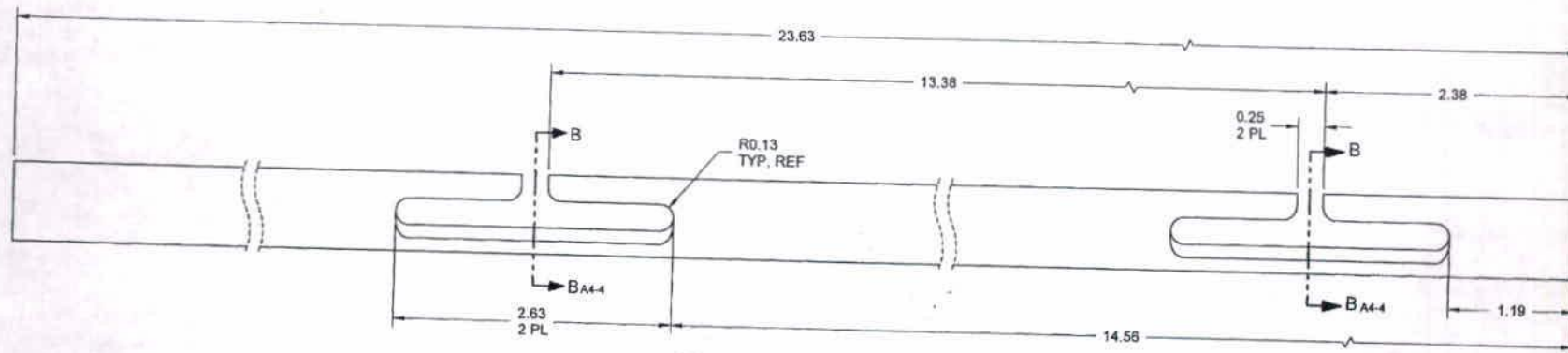
1) MATERIAL -1: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B

-3: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11
REF DART SPEC M6061T6S.080

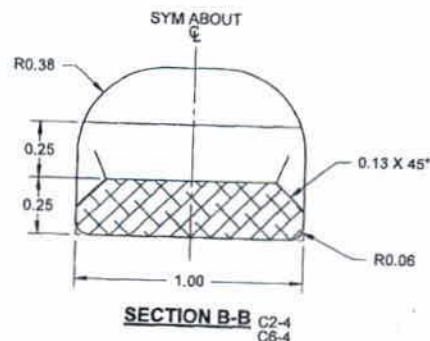
- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -1: 0.53 lbs
-3: 0.03 lbs

**PRELIMINARY
ISSUE**
AJS 09.04.14

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3920	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
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D3920-5 SEATBELT GUIDE



**PRELIMINARY
ISSUE**

AJS 09.04.14
AJS 09.04.23

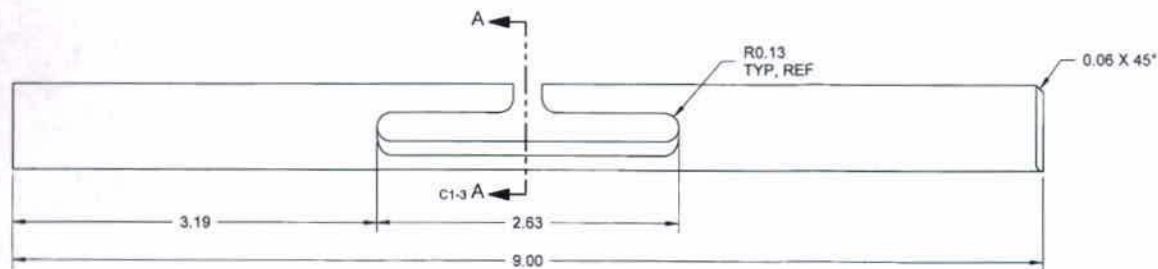
NOTES: D3920-5

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M8061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.44 lbs

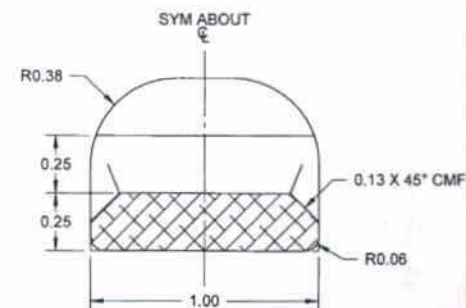
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. <i>[Blank]</i>
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEATBELT GUIDE ASSY (214B/B1)	NTS
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AJS
09.04.23

8 7 6 5 4 3 2 1

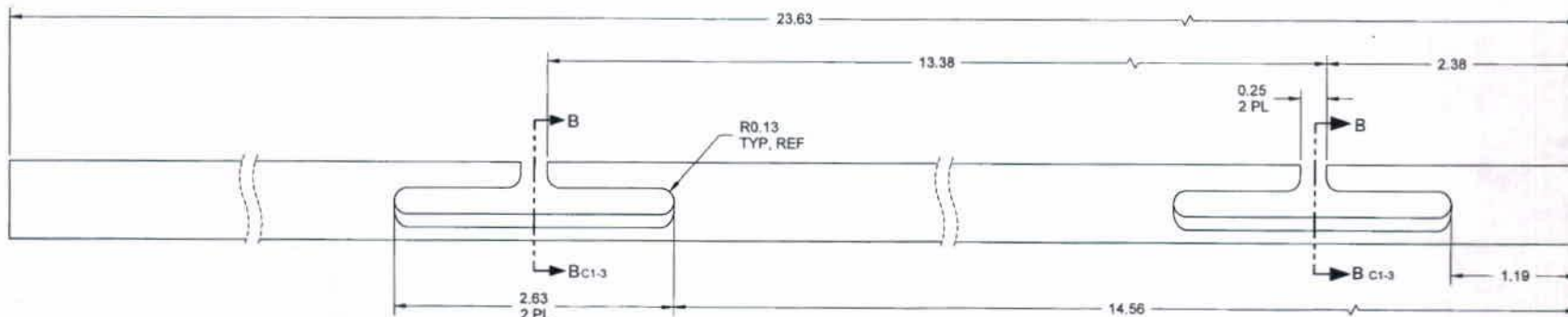


D3920-1 SEATBELT GUIDE



SECTION A-A C6-3
SCALE 2X

SECTION B-B B2-3
SCALE 2X B5-3



D3920-5 SEATBELT GUIDE

NOTES: D3920-1 & 5

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.53 lbs
-5: 1.44 lbs

47231-2

RELEASED
09/04/22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEATBELT GUIDE ASSY (214B/B1)	NTS
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8 7 6 5 4 3 2 1